

Date: Tuesday, 03/06/2008 12:47:38 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEAR PLATE
Job Number : 39666	
Estimate Number : 11231	
P.O. Number :	Part Number : D2348
This Issue : 03/06/2008 S.O. No. :	Drawing Number : D2348 REV B2
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : B2
Previous Run : 39578	Material :
Written By :	Due Date : 15/06/2008 Qty: 50 Um: Each
Checked & Approved By : <u>JULIO 08.6.03</u>	
Comment : Est Rev A Removed from 9 Digit 05-12-05 JLM	
Est Rev:B Now on Waterjet 06-07-03 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S063	6061-T6 .063 Sheet
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Comment: Qty.: 0.0208 sf(s)/Unit Total : 1.0395 sf(s)
 Material: 6061-T6 (QQ-A-250/11) 0.063" thick
 (M6061T6S.063)
 Batch: 107387 IB 8-6-5

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2348
 Dwg Rev: B2
 Prog Rev: B2

IB 8-6-5

(62)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

(08/06/06 (B2))

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr

08/06/06

(62)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 03/06/2008 12:47:38 PM
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Drawing Name: WEAR PLATE

Job Number: 39666

Part Number: D2348

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/06/06 (x62)

7.0

OUTSIDE SERV.20

OUTSIDE SERVICE - SF



Comment: Sub-Contracting PURCHASING

Issue P/O: 6520

Black Anodize per Dwg D2348

Ensure Certificate of Conformity is attached

C 208/06/06 (62)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

P 208/19 (62)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP
INSPECT CERTS

S 08/06/19 (x62)

counter

10.0

FE832EF

PEM Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total: 200.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 FE832EF PEM Insert

M108247 x200
M108224 x48

18 08/06/23 (x62)

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Insert as per Dwg D2348

28 08/06/23 (62)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/06/23 (x62)

counter

W/O:		WORK ORDER CHANGES					
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Drawing Name: WEAR PLATE

Job Number: 39666

Part Number: D2348

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 27

8/6/23

b2

50X
sel

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/25

Job Completion



cd 08/06/25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QA: N/C Closed: _____ Date: _____

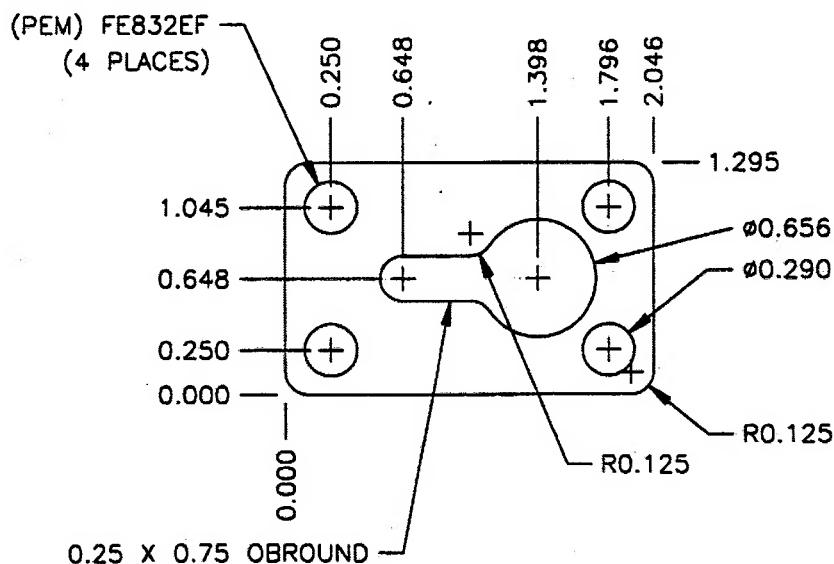
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	B WILLIAMS	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
BW	[Signature]	D2348	SHEET 1 OF 1
DATE	TITLE		SCALE
95:01:20	WEAR PLATE		1:1
B	95:02:20	CHANGED PEM INSERT TO 8-32	
B1	00.03.07	CHANGE TO AISI 304/316 MATERIAL	
B2	02.02.21	CHANGE BACK TO 6061-T6	

RELEASED
97/04/22 DS



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39666

- NOTES:
- 1) MATERIAL: 6061-T6 ALUMINUM SHEET 0.063 THICK PER QQ-A-250/11 (M6061T6S)
 - 2) FINISH: BLACK ANODIZE PER MIL-A-8625F TYPE I/IB/IC/II/IB CLASS 2
 - 3) INSTALL FE832EF INSERTS AFTER ANODIZING
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) TOLERANCES ARE PER PART QSF 01B UNLESS OTHERWISE NOTED.

~~AISI 304/316 SS~~

~~MATERIAL: 6061-T6 ALUMINUM 0.063 THICK, ANODIZE BLACK
AFTER ANODIZING INSTALL (PEM FE832EF) 4 PLACES~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

1 IN 1

ANODISATION et PEINTURE TNM INC.

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified
approuvé NADCAP approved

65597

11-Jun-2008

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

**CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE****NO. DE COMMANDE: 6520
PURCHASE ORDER/**

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	7	7	412-200-002-006 B39	DWG: D41232-200-002 REV. A
4	8	8	D3299-1 B38451	BLACK ANODIZE PER MIL-8625F1, CLASS 2 TYPE 2 DWG: D2399 REV. B
2	62	62	D2348 B39578	BLUE ANODIZE PER MIL-8625F1, CLASS 2 TYPE 2 DWG: D2348 REV. B2
3	62	62	D2348 B39666	BLACK ANODIZE PER MIL-8625F1, CLASS 2 TYPE 2 DWG: D2348 REV. B2
				BLACK ANODIZE PER MIL-8625F1, CLASS 2 TYPE 2

Last Modified on 20-Jun-2008

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.
All parts are processed, tested, and inspected to the requirements of above specifications.
Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed: 

Directeur de la Qualité / Q.A. Manager